

Work Order ID 118441

118441

Page 1

Friday, August 29, 2014 3:04:35 PM

Item ID: D206-667-203

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Crosstube - High 206L / L1 / L3 / L4

Start Date: 8/28/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/29/2014 Req'd Qty: 1.00 *1*

Customer: CEDWAC

Reference: RMA RA111838 - RETURN

Approvals: Process Plan: ME Date: 14-8-29 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

DART AEROSPACE		HAWKESBURY, ON, CANADA	
PATENT	N/A	QIC	CHG004
P/N	D206-667-203	SIC	SH01-5
DESC	Crosstube Aft High	SIC	SR01304NY
LOT	B91700	SIC	
MODEL	Bel206L/L1/L3/L4	SIC	
TC APPROVAL # 08-89		MADE IN CANADA	
		02729-4	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-667-243	Rev C (DEO)
DSI9565	A

100

0.00

100

QC

Quality Control

Memo

0.00

INSPECT RA 111838

D206-667-203 X 1 B118441 91700 CHG 004

KIT IS COMPLETE

ID AND STOCK UNDER NEW BATCH NUMBER

DAS

18

9-89

14/10/07

110

Identify as per dwg & Stock Location: 103 0.00

110

Packaging

Memo

0.00

Packaging

OCT 07 2014 DAS 06 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 118441

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Page 2

Item ID: D206-667-203

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Crosstube - High 206L / L1 / L3 / L4

Start Date: 8/28/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/29/2014 Req'd Qty: 1.00 ***1***

Customer: CEDWA01

Reference: RMA RA111838

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC21- Final Inspection - Work Order Release

0.00

120

QC

Memo

0.00

Quality Control

CHG004

14/10/8 JF

MF
14-10-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Work Order ID: 118441

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Parent Item: D206-667-203

D206-667-203

Parent Item Name: Aft Crosstube - High 206L / L1 / L3 / L4

Start Date: 8/28/2014

Required Date: 8/29/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F 05.09.01 Add holes for compatibility with Bell SkidtubesKJ/JLM
IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec
IPP Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC
IPP Rev:I 08-12-15 add magnobond DD verified by:EC
IPP Rev J 09.01.06 ECN 08-562 EC verified by:DD IPP REV:K
11.08.05 PER ECN 11-615 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-667-203		Manufactured	No				Each	11.0000		1			

D206-667-203

Aft Crosstube - High 206L / L1 / L3 / L4

Location	Loc Qty	Loc Code
FG	6	
100016	1	
100019	1	
104446	1	
97425	1	
97791	1	
99863	1	
FG103	5	
100023	1	
104447	1	
104449	1	
105139	1	
105140	1	

91700 ME
14-8-29

DQA: _____ Date: _____



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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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RA 111838

Received @ Dart August 6th, 2014
Inspected @ Dart August 11th, 2014

CUSTOMER: BELL HELICOPTERS
CUSTOMER CONTACT: CYNDI BERNDIT
SHIPPED FROM: PINEY FLATS TN, USA

Instructions for RA 111838

- See attached pictures for damaged boxes
- **D206-667-103 B97423 118440**
 - Kit is complete
 - Needs new labels and paperwork's
 - Is at current CHG #006
 - Return to stock under new batch #
- **D206-667-203 B91700 118441**
 - Kit is complete
 - Needs new labels and paperwork's
 - Is at current CHG #004
 - Return to stock under new batch #
- **D206-642-511 B105650 118444**
 - Kit is complete
 - Needs new labels and paperwork's
 - Is at current CHG #004
 - Return to stock under new batch #
- **D206-642-512 B106984 118445**
 - Tube is damaged
 - Needs aft cap D2646 and mounting hardware
 - Kit is complete
 - Needs new labels and paperwork's
 - Is at current CHG #004
 - Return to stock under new batch #
- **D206-628-023 B88698 118442**
 - Step is correct (LH re inspected)
 - Kit is complete
 - Needs new labels and paperwork's
 - Is at current CHG #003
 - Return to stock under new batch #
- **D206-628-024 B88699 118443**
 - Step is correct (RH re inspected)
 - Kit is complete
 - Needs new labels and paperwork's
 - Is at current CHG #003
 - Return to stock under new batch #

AN344A x1
NA51515H3L
NA1149 C0332R

DQA: _____ Date: _____



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